

532

DART AEROSPACE LTD	Work Order:	23915
Description: Lug <i>c JAD 0508.01</i>	Part Number:	D2807-3
Dwg: D2807 Rev. B page 2	Qty:	100

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	AP	05/08/02	100
2	MC	Turn as per Folio FA529 and Dwg D2807 Material: 303 Round Bar Ø0.750" (M303R0.750)	Dwg Rev: C Folio Rev: A Batch: M12210	AP	05.08.02 100
3	QC2	Inspect parts as they come off the machine	M17821	AP	05.08.05 100
4	MC	Deburr	SG	05/08/10	100
5	MV	Machine as per Folio FA528 and Dwg D2807	Dwg Rev: C Folio Rev: C	SD	05.08.13 100
6	QC2	Inspect parts as they come off the machine		SD	05.08.13 100
7	MV	Deburr		SD	05.08.13 100
8	QC8	Second check	R	05.08.15	100
9	ST	Identify and Stock	SD	05/08/15	100
10	AC	Cost / part: 4.02	AP	05/08/17	100
11	DC	Close W/O 4.02 Inspect Level 21	AP	05/08/16	100

Rev	Date	Change	Revised By	Approved
A	05.06.02	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED  
*[Signature]*  
*5/15/02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

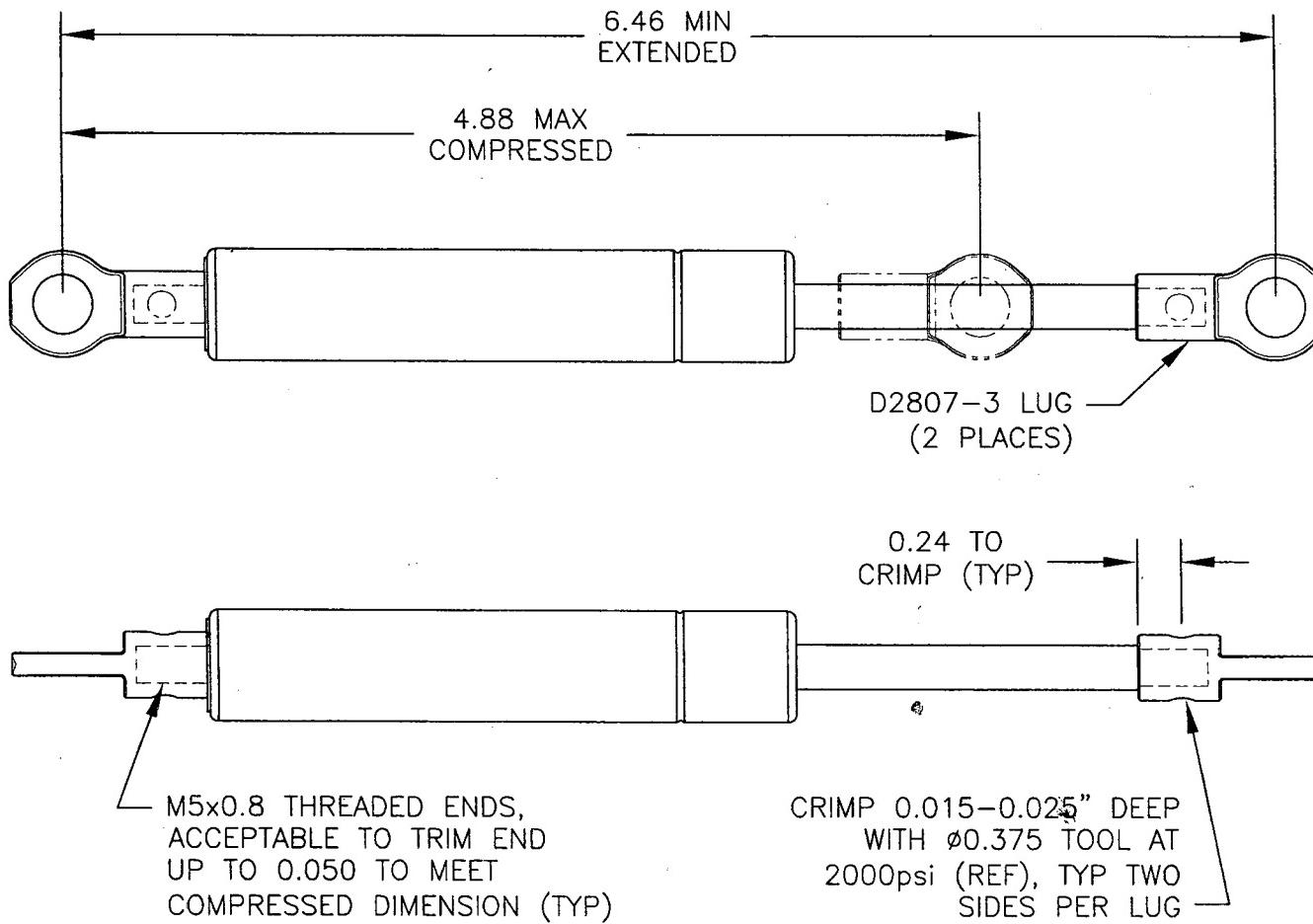
 NoDQA: 

Date: 05/08/17

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

**DART****RELEASED**  
05.05.16**D2807 GAS SPRING**

- SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX  
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK  
P/N: SXF6S6050080S6L-115N  
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN CP		DRAWN BY CP	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA	REV. C
05.05.25		D2807		SHEET 1 OF 2
A	00.11.03	NEW ISSUE		
B	05.03.16	ADD FINISH		
C	05.05.25	CHANGE SPRING PTO;SS; ADD -3 LUG		1:1 SCALE

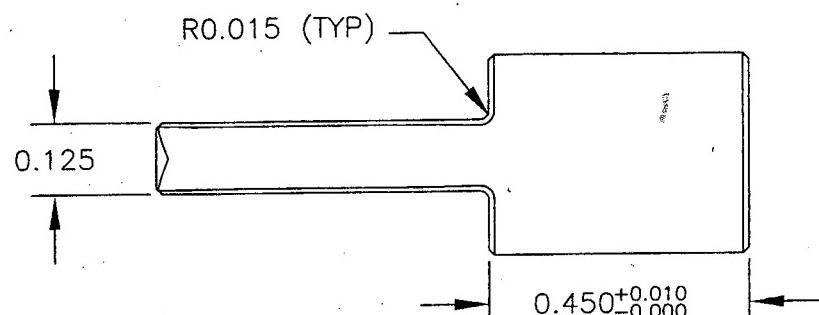
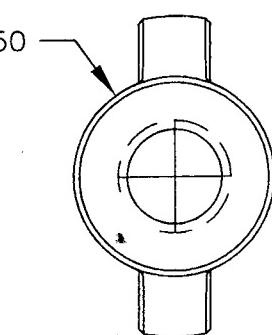
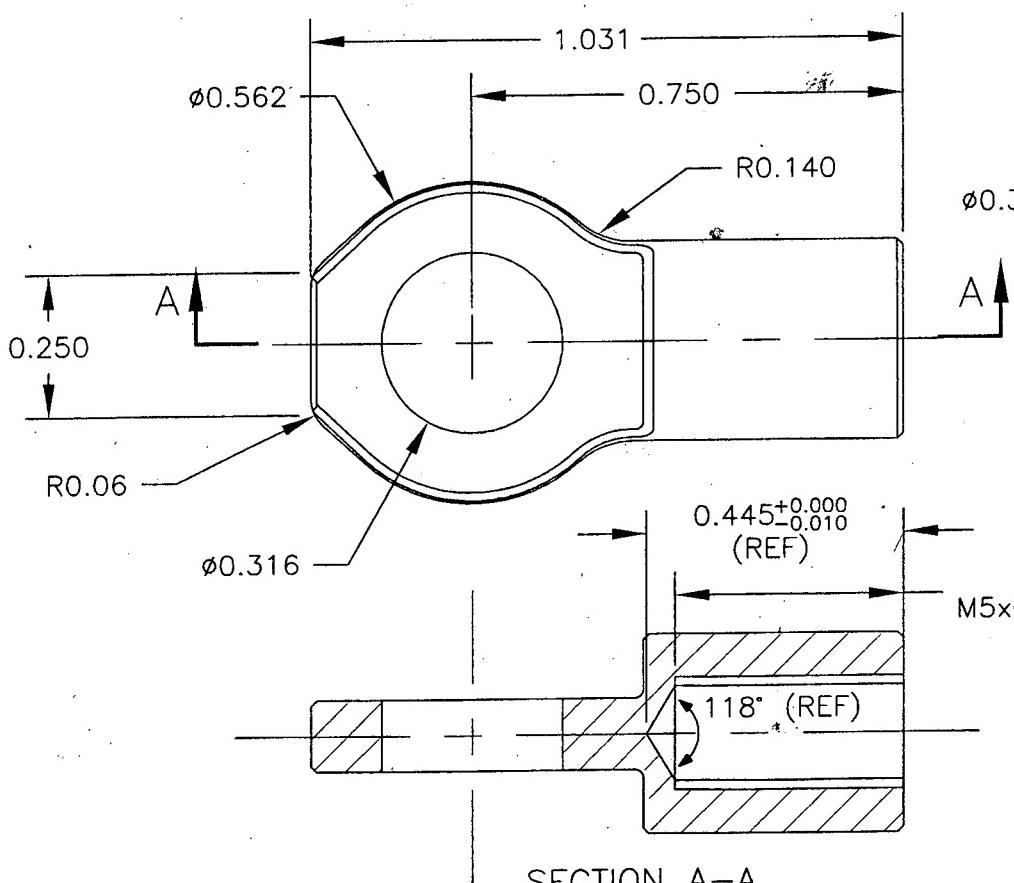
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 2395

RETURN TO  
ENGINEERING

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25		TITLE GAS SPRING	SCALE 3:1

**RELEASED**  
05.06.16 *[Signature]***D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING

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**WITHOUT NOTICE**

**WORK ORDER**  
**NO. 23915**

000000000

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 02, 2005  
01:38 pm

Work Order No : 0023915  
Project Name : D2807-3  
Project For : WK532  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2807-3  
Description : Lug  
Manufactured : Yes  
Amount Req'd : 100  
Amount Done : 0  
Start Date : 08-02-05  
Est Finish Date : 08-10-05  
Act Finish Date :  
Drawings Reqd : No  
Ok for Approval :  
Approval Rec'd : \$0 Posted to Finished Goods

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss)	0.00	0.00

DART AEROSPACE LTD	Work Order:	
Description:	Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## First Article      Prototype

Measured by:	 / SN	Audited by:		Prototype Approval:	
Date:	05-08-07	Date:	05-08-07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	